

Date: Monday, 10/22/2007 4:00:03 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 SADDLE
Job Number : 35315	
Estimate Number : 12451	
P.O. Number :	Part Number : D35001
This Issue : 10/22/2007 S.O. No. :	Drawing Number : D3500 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 32203	Material :
Written By :	Due Date : 11/20/2007 Qty: 24 Um: Each
Checked & Approved By : <u>JA 071023</u>	
Comment : Est Rev:A New Issue 06-06-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6102013	6061-T6 7.0x6.5x2.0
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 24.0000 Each(s)
6061-T6 7.0x6.5x2.0
350 Saddle Billet
Batch: B35951

JA 08/23/24

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. JA Double check by: JA

1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets
4-Deburr
5-Tumble to remove sharp edges.

JA 08/03/24

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JA 08/03/24

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 08/03/28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 4:00:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 35315

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(24)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 08-03-31

6.0

POWDER COATING

POWDER COATING



M 107005



(24K)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-A 08/03/31

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



AS

Comment: INSPECT POWDER COAT

08-03-31

(24K)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5744

AS 08/04/01

(24)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



080402

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-03-31
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35315
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.485	.485	.484	.484		
B	1.175	1.185		1.179	1.179	1.179	1.179		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.179	1.179	1.179	1.179		
E	0.365	0.385		.375	.375	.375	.376		
F	0.490	0.510		.500	.500	.500	.500		
H	R.470	R.530		.525	.525	.525	.525		
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.245	.245	.248	.247		
K	0.490	0.510		.500	.500	.501	.500		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.512		
P	5.990	6.010		6.001	6.001	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.551	.550	.553	.551		
V	0.793	0.803		.799	.799	.799	.799		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.058	.058	.058	.055		
Y	0.100	0.120		.104	.111	.111	.111		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.254	.255	.255	.255		
AE	1.810	1.830		1.820	1.820	1.821	1.820		
AF	0.240	0.260		.252	.255	.252	.252		
AG	0.140	0.160		.150	.149	.149	.150		
AH	0.140	0.160		.150	.150	.150	.150		
AI	0.140	0.160		.147	.145	.145	.145		
Accept/Reject									

Measured by:	<i>S.F.</i>
Date:	<i>08/03/24</i>

Audited by:	<i>J.L.</i>
Date:	<i>08/03/28</i>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	35315
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.483	0.490		.484	.485	.485	.485		
B	1.175	1.185		1.179	1.179	1.179	1.179		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.179	1.179	1.179	1.179		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.500	.500		
H	R.470	R.530		.525	.525	.525	.525		
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.246	.249	.249	.245		
K	0.490	0.510		.501	.500	.500	.500		
L	3.590	3.650		3.625	3.625	3.624	3.625		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.512		
P	5.990	6.010		6.002	6.002	6.002	6.002		
Q	2.820	2.830		2.820	2.820	2.820	2.820		
R	2.495	2.505		2.501	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.553	.553	.552	.553		
V	0.793	0.803		.800	.800	.800	.800		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.054	.058	.058	.055		
Y	0.100	0.120		.112	.112	.112	.115		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.251	.251	.256	.252		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.255	.255	.255	.252		
AG	0.140	0.160		.152	.152	.152	.152		
AH	0.140	0.160		.147	.149	.149	.149		
AI	0.140	0.160		.149	.150	.150	.150		
Accept/Reject									

Measured by:	JS
Date:	08/03/24

Audited by:	JL
Date:	08/03/28

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	35315
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9x	10x	11x	12x	By	Date
A	0.483	0.490		.484	.484	0.487	0.487		
B	1.175	1.185		1.179	1.179	1.178	1.178		
C	3.145	3.155		3.150	3.150	3.148	3.149		
D	1.175	1.185		1.179	1.179	1.178	1.178		
E	0.365	0.385		.375	.375	0.375	0.375		
F	0.490	0.510		.501	.500	0.4985	0.499		
H	R.470	R.530		.525	.525	0.525	0.525		
I	R1.575	R1.595		1.585	1.584	1.5855	1.582		
J	0.240	0.260		0.244	0.244	0.245	0.245		
K	0.490	0.510		.501	.501	0.500	0.500		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		.320	.320	0.320	0.320		
N	0.256	0.262		.258	.258	0.259	0.259		
O	6.500	6.520		6.510	6.512	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.499	2.498		
S	2.245	2.255		2.250	2.250	2.248	2.248		
T	1.120	1.130		1.125	1.125	1.124	1.125		
U	0.540	0.560		0.552	0.553	0.551	0.551		
V	0.793	0.803		.800	.800	0.800	0.800		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		0.055	0.055	0.055	0.055		
Y	0.100	0.120		0.110	0.110	0.105	0.108		
AA	R1.125	R1.145		1.135	1.134	1.135	1.136		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		.635	.631	0.630	0.635		
AD	0.240	0.260		.252	.252	0.254	0.254		
AE	1.810	1.830		1.820	1.820	1.820	1.822		
AF	0.240	0.260		.252	.255	0.254	0.256		
AG	0.140	0.160		.150	.150	0.150	0.151		
AH	0.140	0.160		0.151	0.151	0.149	0.149		
AI	0.140	0.160		0.148	0.149	0.145	0.149		
Accept/Reject									

Measured by:	2F / BTP
Date:	08/03/24 / 08/03/25

Audited by:	SL
Date:	08/03/28

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	[Signature]

DART AEROSPACE LTD		Work Order:	35315
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	14	15	16	By	Date
A	0.483	0.490		0.487	0.487	0.487	0.487		
B	1.175	1.185		1.178	1.179	1.180	1.180		
C	3.145	3.155		3.149	3.150	3.150	3.150		
D	1.175	1.185		1.179	1.180	1.180	1.179		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.501	0.499	0.499		
H	R.470	R.530		R0.525	0.525	0.525	0.525		
I	R1.575	R1.595		1.5895	1.585	1.5855	1.586		
J	0.240	0.260		0.2443	0.2465	0.246	0.2455		
K	0.490	0.510		0.499	0.498	0.499	0.499		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		0.320	0.320	0.320	0.320		
N	0.256	0.262		0.259	0.259	.259	.259		
O	6.500	6.520		6.510	6.510	6.510	6.509		
P	5.990	6.010		6.000	6.000	6.000	6.001		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.249	2.248	2.248	2.249		
T	1.120	1.130		1.124	1.124	1.124	1.124		
U	0.540	0.560		0.551	0.55	0.552	0.5515		
V	0.793	0.803		0.800	.800	.800	0.800		
W	R.240	R.260		0.250	.250	.250	.250		
X	0.040	0.060		0.055	.055	0.055	0.055		
Y	0.100	0.120		0.110	0.110	0.110	0.110		
AA	R1.125	R1.145		1.138	1.135	1.1355	1.1365		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		0.254	0.2555	0.256	0.256		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.256	0.254	0.254	0.254		
AG	0.140	0.160		0.151	0.149	0.150	0.150		
AH	0.140	0.160		0.149	0.149	0.149	0.149		
AI	0.140	0.160		0.148	0.150	0.150	0.150		
Accept/Reject									

Measured by:	DJP
Date:	08/03/25

Audited by:	J.L
Date:	08/03/28

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	35315
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500		Rev: C	Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17	18	19	20	By	Date
A	0.483	0.490		0.487	0.487	0.487	0.487		
B	1.175	1.185		1.180	1.177	1.179	1.1795		
C	3.145	3.155		3.150	3.150	3.151	3.150		
D	1.175	1.185		1.180	1.179	1.179	1.179		
E	0.365	0.385		0.375	0.375	0.375	0.375		
F	0.490	0.510		0.500	0.500	0.4965	0.497		
H	R.470	R.530		0.505	0.505	0.505	0.505		
I	R1.575	R1.595		1.5855	1.586	1.5865	1.5855		
J	0.240	0.260		0.246	0.246	0.248	0.248		
K	0.490	0.510		0.499	0.499	0.499	0.500		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		0.320	0.320	0.320	0.320		
N	0.256	0.262		0.259	0.259	0.259	0.259		
O	6.500	6.520		6.508	6.508	6.508	6.508		
P	5.990	6.010		6.005	6.005	6.005	6.005		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.501	2.501	2.498	2.500		
S	2.245	2.255		2.249	2.250	2.250	2.250		
T	1.120	1.130		1.124	1.124	1.125	1.125		
U	0.540	0.560		0.553	0.552	0.552	0.550		
V	0.793	0.803		0.800	0.800	0.800	0.800		
W	R.240	R.260		0.250	0.250	0.250	0.250		
X	0.040	0.060		0.055	0.055	0.055	0.058		
Y	0.100	0.120		0.106	0.108	0.108	0.108		
AA	R1.125	R1.145		1.1355	1.136	1.1365	1.1355		
AB	R.490	R.510		0.500	0.500	0.500	0.500		
AC	0.615	0.635		0.630	0.630	0.630	0.630		
AD	0.240	0.260		0.2555	0.2555	0.256	0.256		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		0.253	0.253	0.254	0.254		
AG	0.140	0.160		0.150	0.150	0.151	0.149		
AH	0.140	0.160		0.152	0.152	0.152	0.153		
AI	0.140	0.160		0.150	0.150	0.150	0.151		
Accept/Reject									

Measured by:	DJP
Date:	08/03/25

Audited by:	JL
Date:	08/03/28

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	<i>[Signature]</i>

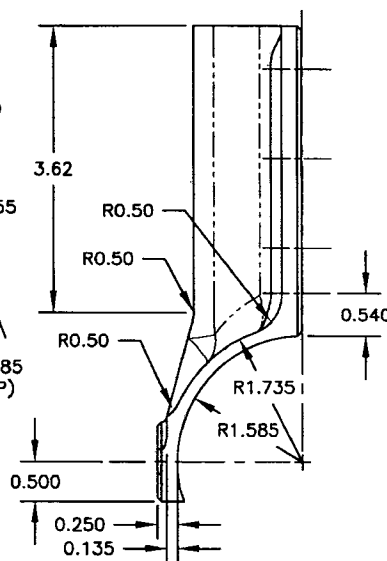
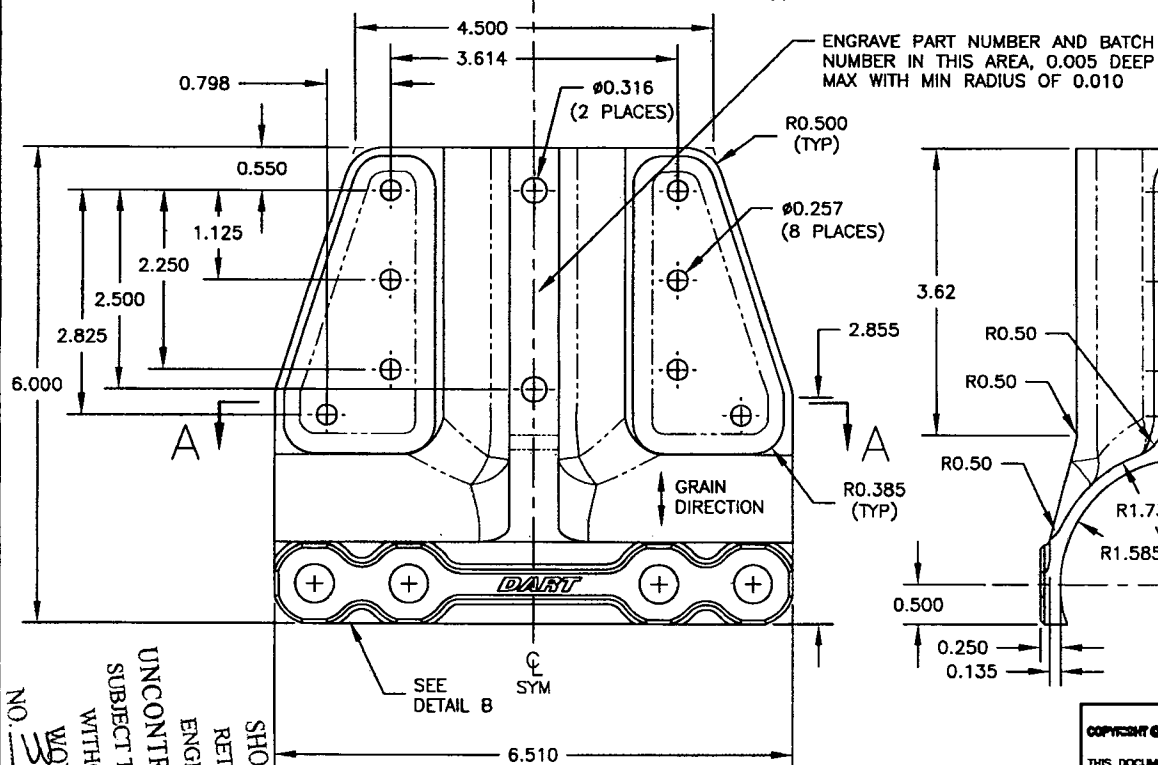
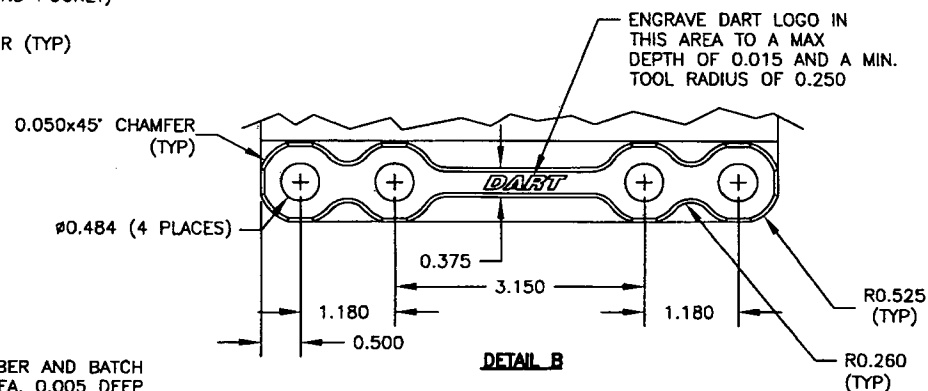
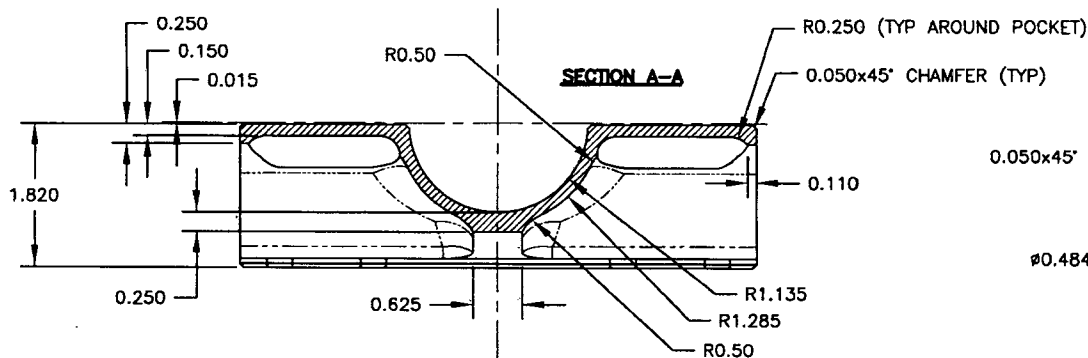
DART AEROSPACE LTD		Work Order:	35315
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C		Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	By	Date
A	0.483	0.490		0.487	0.487	0.487	0.487		
B	1.175	1.185		1.179	1.179	1.179	1.179		
C	3.145	3.155		3.150	3.149	3.150	3.150		
D	1.175	1.185		1.180	1.181	1.181	1.1805		
E	0.365	0.385		0.375	0.375	.375	0.375		
F	0.490	0.510		0.497	0.502	0.501	0.501		
H	R.470	R.530		0.525	0.525	0.525	0.525		
I	R1.575	R1.595		1.585	1.5885	1.587	1.5865		
J	0.240	0.260		0.247	0.247	0.246	0.247		
K	0.490	0.510		0.500	0.500	0.500	0.500		
L	3.590	3.650		3.625	3.625	3.625	3.625		
M	0.315	0.320		0.320	0.320	.320	.320		
N	0.256	0.262		0.259	0.259	.259	.259		
O	6.500	6.520		6.508	6.508	6.508	6.508		
P	5.990	6.010		6.006	6.006	6.006	6.005		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.498	2.498	2.499	2.4985		
S	2.245	2.255		2.251	2.251	2.250	2.251		
T	1.120	1.130		1.125	1.125	1.1245	1.125		
U	0.540	0.560		0.5495	0.549	0.550	0.5505		
V	0.793	0.803		0.800	0.800	0.800	0.800		
W	R.240	R.260		0.250	0.250	.250	.250		
X	0.040	0.060		0.057	0.057	0.057	0.057		
Y	0.100	0.120		0.108	0.108	0.108	0.108		
AA	R1.125	R1.145		1.135	1.138	1.1365	1.1355		
AB	R.490	R.510		0.500	0.500	.500	.500		
AC	0.615	0.635		0.630	0.630	.630	.630		
AD	0.240	0.260		0.256	0.2555	0.256	0.2555		
AE	1.810	1.830		1.822	1.822	1.822	1.820		
AF	0.240	0.260		0.256	0.256	0.257	0.255		
AG	0.140	0.160		0.151	0.151	0.151	0.1495		
AH	0.140	0.160		0.152	0.152	0.153	0.151		
AI	0.140	0.160		0.150	0.150	0.150	0.151		
Accept/Reject									

Measured by:	DJP
Date:	08/03/26

Audited by:	JL
Date:	08/03/28

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11)
(MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1,
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06-08-15 #

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	92	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	06.06.30	TITLE SADDLE
DRAWING NO. D3500		REV. C SHEET 1 OF 1
DART AEROSPACE LTD. WINDERMERE, ONTARIO, CANADA		SCALE

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